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Split 4

DART AEROSPACE LTD		Work Order: 24132
Description: Dart 13-Man Shoulder Harness Kit (205/212/214/412)		Part Number: D3197-1 D412-702-011
Dwg: D3195 Rev. A; D3196 Rev. A; D3197 Rev. A Ref: D412-702 Rev. A page 9		Qty: 630 Kit(s) Page 1 of 4

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: D412-702-011 Kit consists of (2) D3195-041; (2) D3195-043; (1) D3196-1; (1) D3196-3; (1) D3196-4; (2) D3197-041.	U	05/08/31	36
2	DC	Photocopy bluefile and create labels per PPP D412-702-011 CHG001			
3	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 2.00") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B0.750x02.000) Identify for D3195-1 Batch:			
4	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (1.50" x 1.25") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.500x01.250) Identify for D3195-3 Batch:			
5	MV	Cut blank: (0.75" x 1.50") x 26.200" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify for D3196-1 Batch:	W/A		
6	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 1.50") x 34.750" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify (1) for D3196-3 Identify (1) for D3196-4 Batch:			
7	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: 29.125" long Round Bar Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) Identify for D3197-1 Batch: m10453	Er	05/07/13	28
8	MV	Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr and Tumble			
11	QC8	Second check			
12	MV	Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3			
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr and Tumble			
15	QC8	Second check			

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DART AEROSPACE LTD		Work Order:	24/32
Description: Dart 13-Man Shoulder Harness Kit (205/212/214/412)		Part Number:	D3197-1 D412-702-011
Dwg: D3195 Rev. A; D3196 Rev. A; D3197 Rev. A		Qty:	30 Kit(s)
Ref: D412-702 Rev. A page 9		Page 2 of 4	

Step	Location	Procedure	By	Date	Qty
16	MV	Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1			
17	QC2	Inspect parts as they come off the CNC machine			
18	MV	Deburr			
19	QC8	Second check			
20	MV	Machine D3196-3 as per Folio FA339 and Dwg D3196 Identify as D3196-3			
21	QC2	Inspect parts as they come off the CNC machine			
22	MV	Deburr			
23	QC8	Second check			
24	MV	Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4			
25	QC2	Inspect parts as they come off the CNC machine			
26	MV	Deburr			
27	QC8	Second check			
28	MV	Machine D3197-1 as per Folio FA340 and Dwg D3197 Note: Need to be faced to size Identify as D3197-1	SD/	05.09.15	27
29	QC2	Inspect parts as they come off the CNC machine	SD/	05.09.15	27
30	MV	Deburr	SD/	05.09.15	27
31	QC8	Second check	SD/	05.09.15	27
32	FP	Chemical Conversion Coat as per QSI 005 4.1 D3195-1/-3; D3196-1/-3/-4; (D3197-1)	FC	05.09.20	27
33	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3195-1/-3; D3196-1/-3/-4; (D3197-1)	FC	05.09.21	27
34	QC3	Inspect work to Step 33	MM	05.09.21	27
35	GA	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 0.500") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber - 2.500" Punch holes as per Dwg Identify as D3195-5 Batch: _____			
36	GA	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 1.000") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber - 2.500" Punch holes as per Dwg Identify as D3195-7 Batch: _____			

DART AEROSPACE LTD		Work Order:	24/32
Description: Dart 13-Man Shoulder Harness Kit (205/212/214/412)		Part Number:	D3197-1 D412-702-011
Dwg: D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		Qty:	30 Kits
Ref: D412-702 Rev. A page 9		Page 3 of 4	

Step	Location	Procedure	By	Date	Qty
37	GA	Bond D3195-5 into D3195-1 as per Dwg D3195 Pick: Qty _____ Description _____ Batch _____ A/R _____ Contact Cement			
38	GA	Bond D3195-7 into D3195-3 as per Dwg D3195 Pick: Qty _____ Description _____ Batch _____ A/R _____ Contact Cement			
39	QC5	Inspect work to Step 38			
40	GA	Assemble (2) D3197-041 as per Dwg D3197. (Note: D3197-1 is on BOM as material from Step 7) Pick: Qty Part Number Description Batch 4 D2690-5 Lanyard B24284 2 D3197-1 Bar B24165 4 D3242-1 Tag B24132 12 AN960JD10 Washer H17634 4 DARS-0048 Hip Pin M186017 H17634 4 MS21042L3 Nut (or -3) H17652 4 MS27039-1-24 Bolt H17652 Identify as D3197-041 H3283			
41	QC5	Inspect work to Step 40		5/11/16	3
42	KP	Pick: Packing Kit (Note: D3195-041/-043, D3196-1/-3/-4 are on BOM as material from Steps 3-6, 35-36) Qty Part Number Description Batch 2 D3195-041 Bracket 2 D3195-043 Bracket 1 D3196-1 Bar 1 D3196-3 Bar 1 D3196-4 Bar 2 D3197-041 Bar 4 D3198-1 Fitting 18 D3215-041 Harness Assembly 4 D3215-043 Harness Assembly 4 AN4-5A Bolt 4 AN4-13A Bolt 8 AN4-20A Bolt 20 AN960JD416 Washer 12 MS21042L4 Nut (or -4) 8 MS24694-S152 Screw 2 D3268-1 Placard		05-11-17	3
43	QC4	Inspect Kit 100% for Completeness on the W/O			
44	PK	Identify and pack for shipping as per PPP D412-702-011 ID + stack		05/11/16	6

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Ref: D412-702 Rev.A page 9		Page 4 of 4	

Step	Location	Procedure	By	Date	Qty
45	AC	Cost / part			
46	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	03.10.17	New issue	KJ/RF	

RELEASED
04.06.23

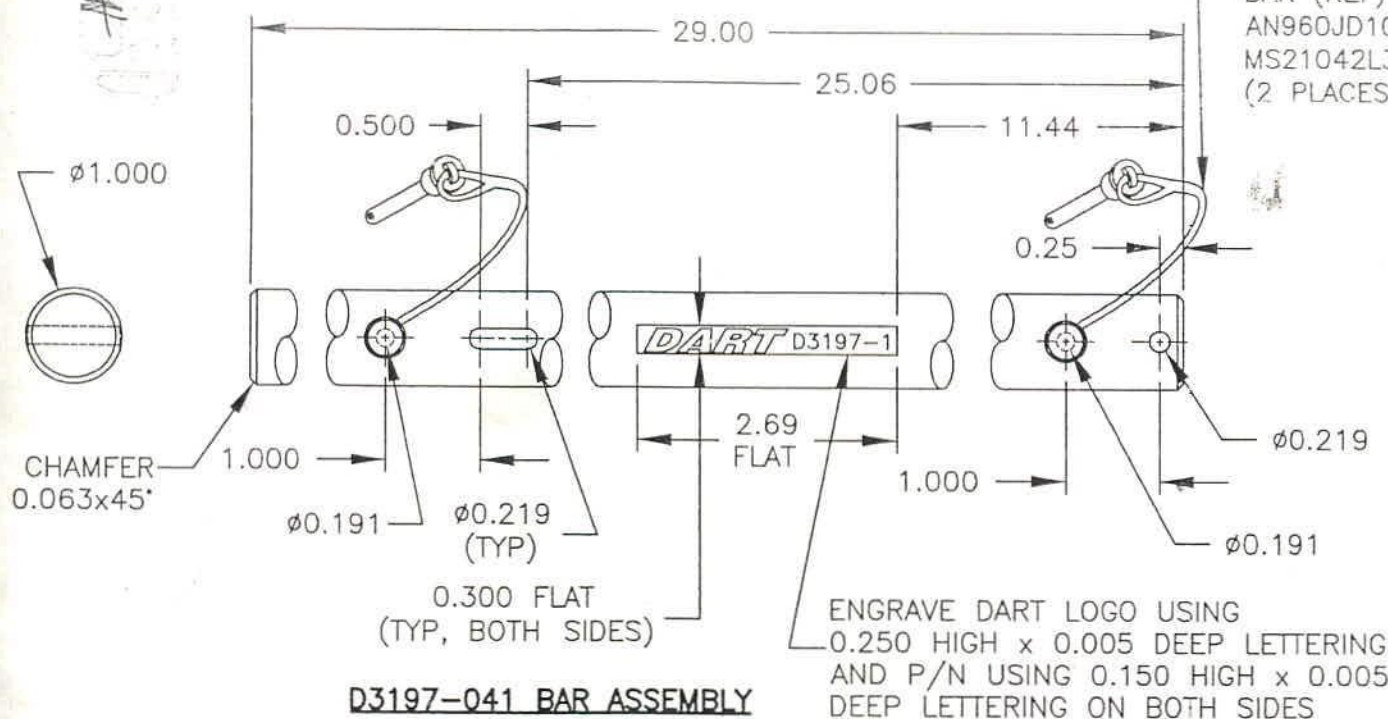
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24132

AI D3242-1 TAG (i)
 DARS-004 PIP PIN (1)
 MS27039-1-24 BOLT (1)
 AN960JD10 WASHER (1)
 D2690-5 LANYARD (1)
 AN960JD10 WASHER (1)
 BAR (REF)
 AN960JD10 WASHER (1)
 MS21042L3 NUT (1)
 (2 PLACES)

**D3197-041 BAR ASSEMBLY****D3197-1 BAR**

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A ϕ 0.188 DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		
03.07.01	03.07.01	NEW ISSUE
AI	04.01.12	ADD D3242-1 TAG
		BAR
		TITLE
		D3197
		DRAWING NO.
		SHEET 1 OF 1
		SCALE
		1:1
		REV. A